

Work Order ID 82885

Tuesday, April 10, 2012 2:30:10 PM

82885

Page 1

Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Base Assembly, 350
 Start Date: 4/10/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/20/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *P* Date: *12-04-10* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A
D4020	A

100 Weld per dwg A/R S.S. rod Batch: *118366* 0.00
 Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

12 04 26

12-04-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Accept

N900040100Setup Start ***NS1***

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Start Date: 4/10/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

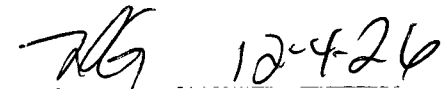
125

HandFinish

Memo

0.00

Hand Finishing



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130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes and mask only interior of hinge (3) prior to powder coat								
	1ST COAT: 8-30								
	START TIME: 8-30								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 9-00								
	***** 2nd coat if necessary*****								
	2ND COAT: 9-30								
	START TIME: 9-30								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 10-00								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

MI 21134

IX 12/04/27

1 12-4-27

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Packaging

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180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/4/30 *[Signature]*
MF 12-04-27

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Picklist Print

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D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

10.0000

2

2

D2581

Mounting Bracket

**

B82017 (2) Ae 12.04.23

Location

Loc Qty

Loc Code

WA005

10

69739

1

70766

2

77045

1

81253

6

D3913-1

Manufactured

No

100

Each

8.0000

1

1

D3913-1

Rib

**

B81195 (1) Ae 12.04.23

Location

Loc Qty

Loc Code

WA

2

74145

0

80790

2

WA006

6

81437

6

D3913-15

Manufactured

No

100

Each

13.0000

1

1

D3913-15

Wide Handle Plate

**

Ae 12.04.23

Location

Loc Qty

Loc Code

WA

11

81440

6

82510

5

WA005

2

80778

2

W/O:		WORK ORDER CHANGES					
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D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-3 Manufactured No

100 Each 9.0000 1 1

D3913-3

Rib

**

B82921 ① Ae 12.04.23

Location Loc Qty Loc Code

WA	6	
69160	0	
74144	0	
81443	6	
WA006	3	
69160	1	
78287	1	
81714	1	

D3913-7 Manufactured No

100 Each 2.0000 2 2

D3913-7

Rib

**

B82924 ② Ae 12.04.23

Location Loc Qty Loc Code

WA006	2	
81439	2	

D3913-9 Manufactured No

100 Each 10.0000 1 1

D3913-9

Hinge Rib

**

B83227 ① Ae 12.04.23

Location Loc Qty Loc Code

WA	9	
81200	9	
WA006	1	
70138	1	

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Page 2

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Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D3916-041	Manufactured	No	100	Each	8.0000	2	2	
								**
D3916-041								B82932 (2) Ae 12.04.23
Rib Assembly								

Location	Loc Qty	Loc Code
WA006	8	
80824	6	
81444	2	

D3916-5	Manufactured	No	100	Each	1.0000	3	3	
								**
D3916-5								B77142 (3) Ae 12.04.23
Light Rib								

Location	Loc Qty	Loc Code
WA	1	
81434	1	

D4016-1	Manufactured	No	100	Each	12.0000	3	3	
								**
D4016-1								B82709 (3) Ae 12.04.23
Hinge Half, Base								

Location	Loc Qty	Loc Code
WA	12	
66418	0	
81702	12	

D4017-7	Manufactured	No	100	Each	13.0000	1	1	
								**
D4017-7								Ae 12.04.23
Rib								

Location	Loc Qty	Loc Code
WA	6	
78327	6	
WA005	7	
69730	1	
<u>81176</u>	6	

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Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D4017-9 Manufactured No

100 Each 13.0000 2 2

D4017-9

Rib

**

B83233 (2) to 12.04.23

Location	Loc Qty	Loc Code
WA	6	
81445	6	
WA006	7	
70341	2	
73531	4	
81515	1	

D4020-11 Manufactured No

100 Each 8.0000 2 2

D4020-11

End Mesh, Basket

**

Pl 12.04.26

Location	Loc Qty	Loc Code
WA	-4	
81442	8	
WA035	12	

B813 70 -> (2)

D4021-1 Manufactured No

100 Each 35.0000 3 3

D4021-1

Handle Plate

**

to 12.04.23

Location	Loc Qty	Loc Code
WA	14	
69518	0	
74316	0	
74946	0	
81181	4	
82509	10	
WA005	21	
80826	21	

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D4034-041 Manufactured No

100 Each 8.0000 1 1

D4034-041

Aft Upper Rib Assembly

**

Ac 12.04.23

Location Loc Qty Loc Code

WA 6

81170 6

WA006 2

81171 2

D4034-043 Manufactured No

100 Each 6.0000 1 1

D4034-043

Fwd Upper Rib Assembly

**

Ac 12.04.23

Location Loc Qty Loc Code

WA 6

81173 6

M304EX0.75-16F Purchased No

100 sf 677.2254 33 33

M304EX0 75-16F

Expanded Metal Flat SS

**

PC 12.04.26

Location Loc Qty Loc Code

WA 0.0001156

119180 0.0001156

WA035 677.2252641

117197 102.9036

117896 29.49258

118153 76.8473

118955 82.17

119180 53.6958107

119729 28.1132686

120153 2.97557478

120917 170.88713

121082 130.14

m/21347 - 33

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Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No

150 Each 316.0000 6 6 ✓

AN3-10A

Bolt

**

JB

Location

Loc Qty

Loc Code

GA

18

119084

18

ST351

298

117795

2

120873

296

120813

AN960JD8 NAS1149DN832 Purchased No

150 Each 0.0000 2 2

AN960JD8

Washer

**

120422 JB

D2931 Manufactured No

150 Each 474.0000 2 2 ✓

D2931

Bumper

**

JB

Location

Loc Qty

Loc Code

ST504

474

46064

474

46064

D4021-5 Manufactured No

150 Each 10.0000 2 2 ✓

D4021-5

Blanking Plate

**

82974 JB 12/04/27

Location

Loc Qty

Loc Code

ST084

10

81183

8

81438

2

~~381181~~

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Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,124.000

2

2

✓

MS20600-AD4W3

**

JB

Cherry Rivets

Location

Loc Qty

Loc Code

ST321

991

111636

36

117601

17

118626

598

120308

340

118626

WA018

133

107939

133

MS21042L3

Purchased

No

150

Each

2,198.000

6

6

✓

MS21042L3

**

121349 JB

12/04/27

Nut

Location

Loc Qty

Loc Code

ST300

2198

117441

16

117885

32

118451

5

118927

3

119017

1976

119075

166

Dart Aerospace Ltd

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Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

690.0000

12

12

✓

NAS1149F0332P

JB 12/04/27

WASHER

Location

Loc Qty

Loc Code

ST275

690

117735

37

119225

10

120910

198

120986

200

121166

42

121259

200

17317

3

120910

W/O:		WORK ORDER CHANGES					
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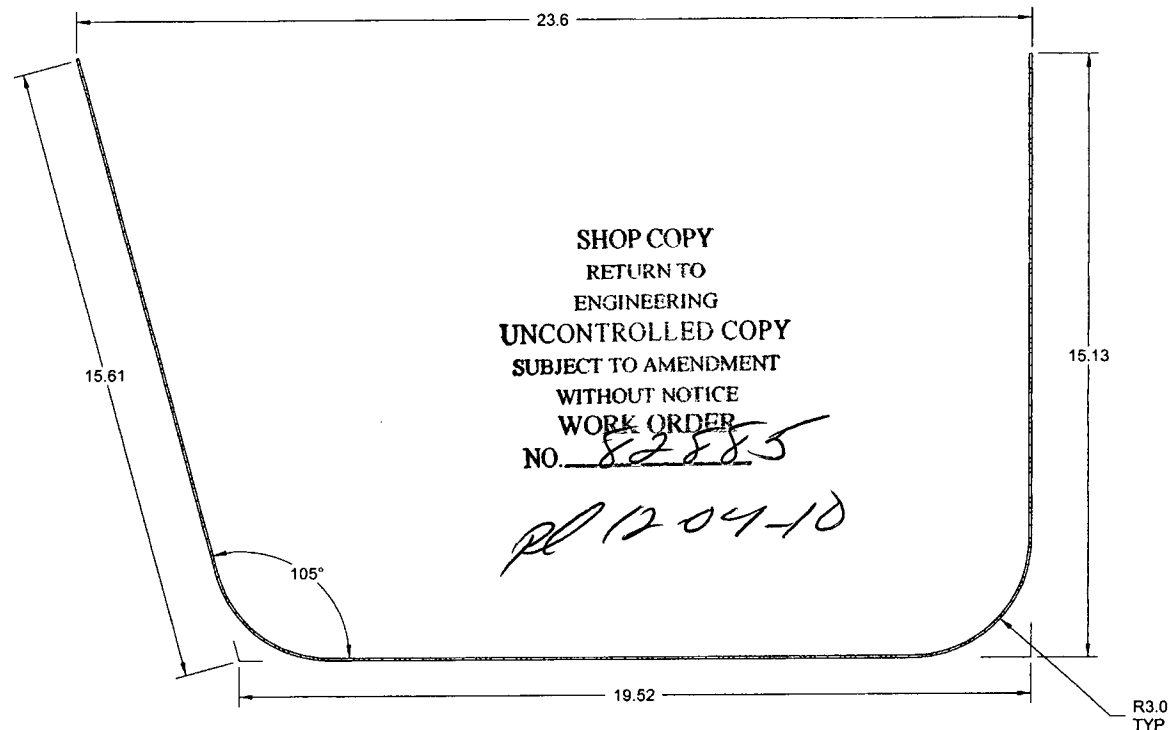
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 82585

PL 1204-10



9 D4020-1 MESH (350 BASKET LONG, BASE)
 (SEE D4020-1F FOR LENGTH)

9 D4020-3 (350 BASKET SHORT, BASE)
 (SEE D4020-3F FOR LENGTH)

RELEASED
 2010-03-12
WJ

NOTES:

- 1) MATERIAL-1: MAKE FROM D4020-1F
 -3: MAKE FROM D4020-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE D4020-1F & D4020-3F
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>WJ</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>WJ</i>	D4020	SHEET 1 OF 4
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

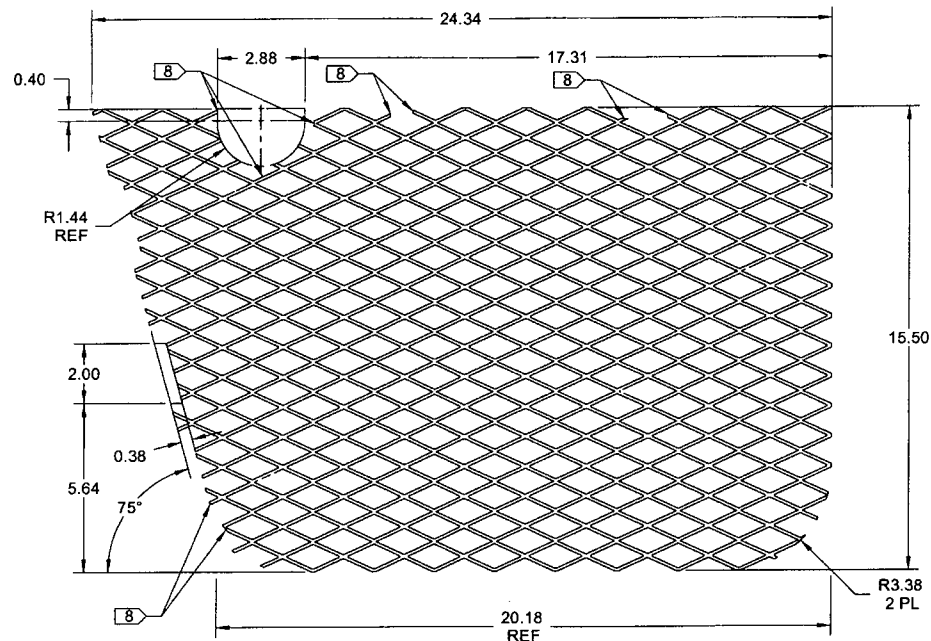
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



[9] D4020-11 END MESH, BASKET

82855

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
JMD

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JP	DRAWING NO. D4020	REV. A
MFG. APPR.	JP		SHEET 3 OF 4
APPROVED	JMD	TITLE	SCALE
DE APPR.	JMD	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

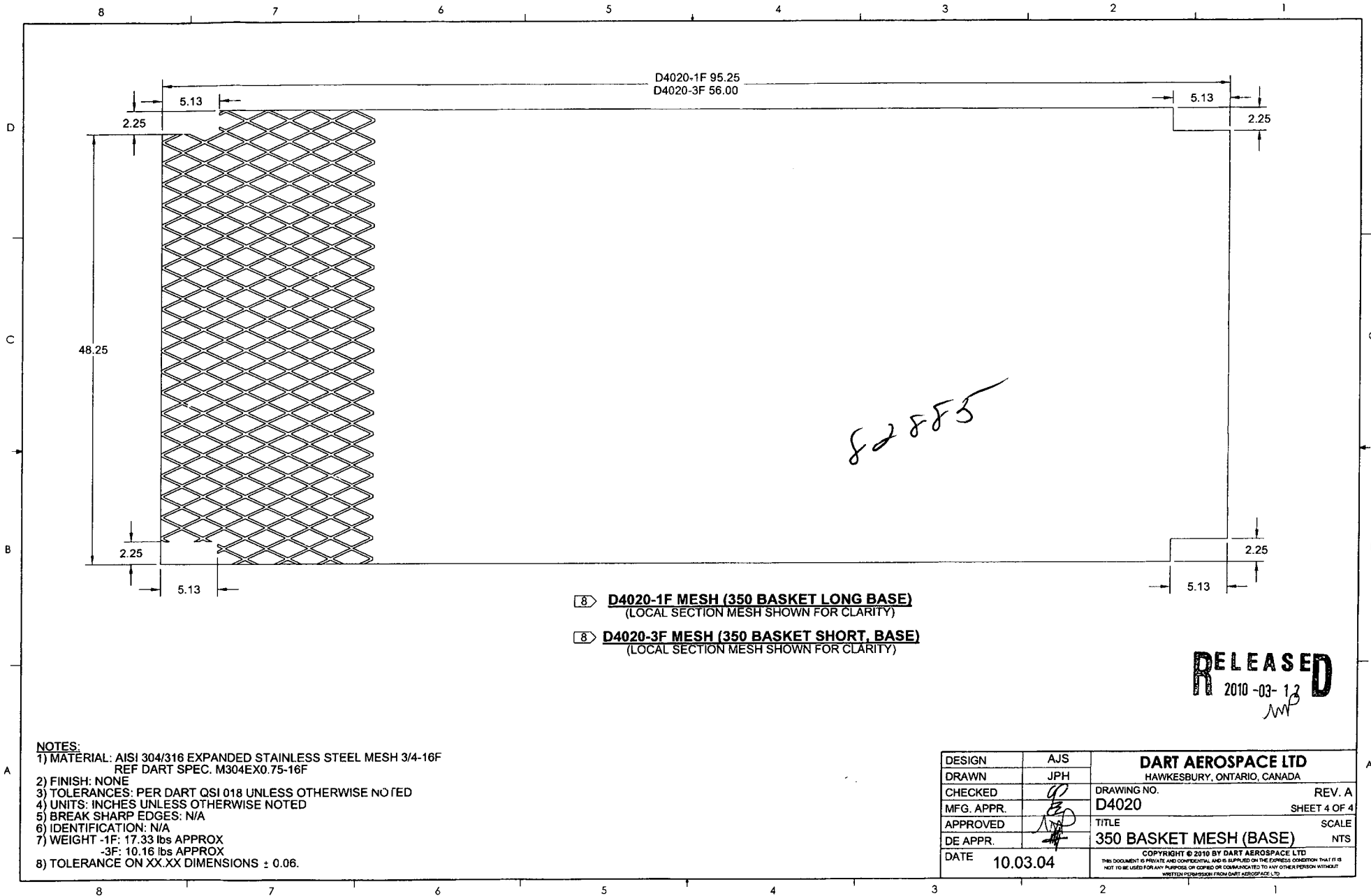
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- 8 D4020-1F MESH (350 BASKET LONG BASE)
(LOCAL SECTION MESH SHOWN FOR CLARITY)
- 8 D4020-3F MESH (350 BASKET SHORT, BASE)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

RELEASED
2010-03-13
MW

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -1F: 17.33 lbs APPROX
-3F: 10.16 lbs APPROX
8) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JP	DRAWING NO. D4020	REV. A
MFG. APPR.	ED	SHEET 4 OF 4	
APPROVED	MW	TITLE 350 BASKET MESH (BASE)	SCALE NTS
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DATE	10.03.04		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

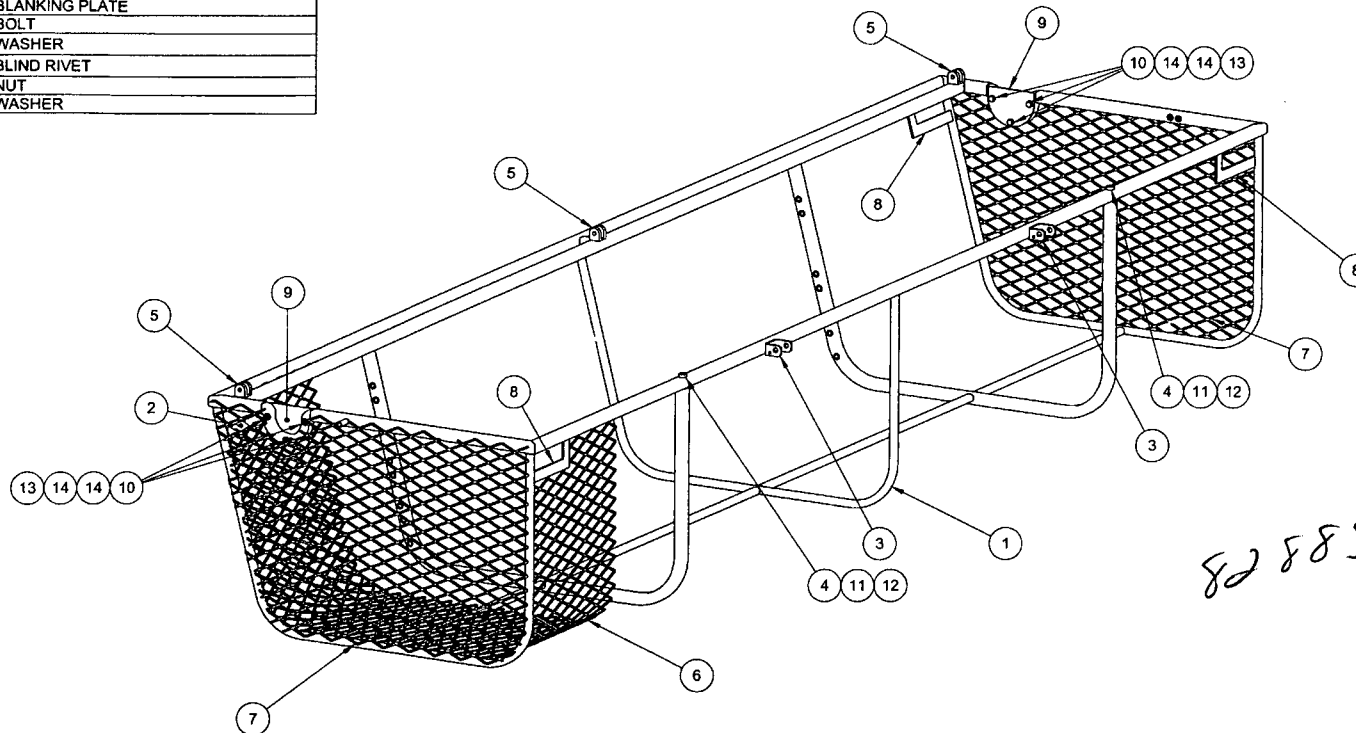
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22
JPH

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWING NO. D3913	REV. A
TITLE LONG BASKET BASE ASSY (350) NTS		SCALE	SHEET 1 OF 6
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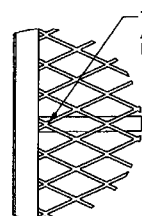
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

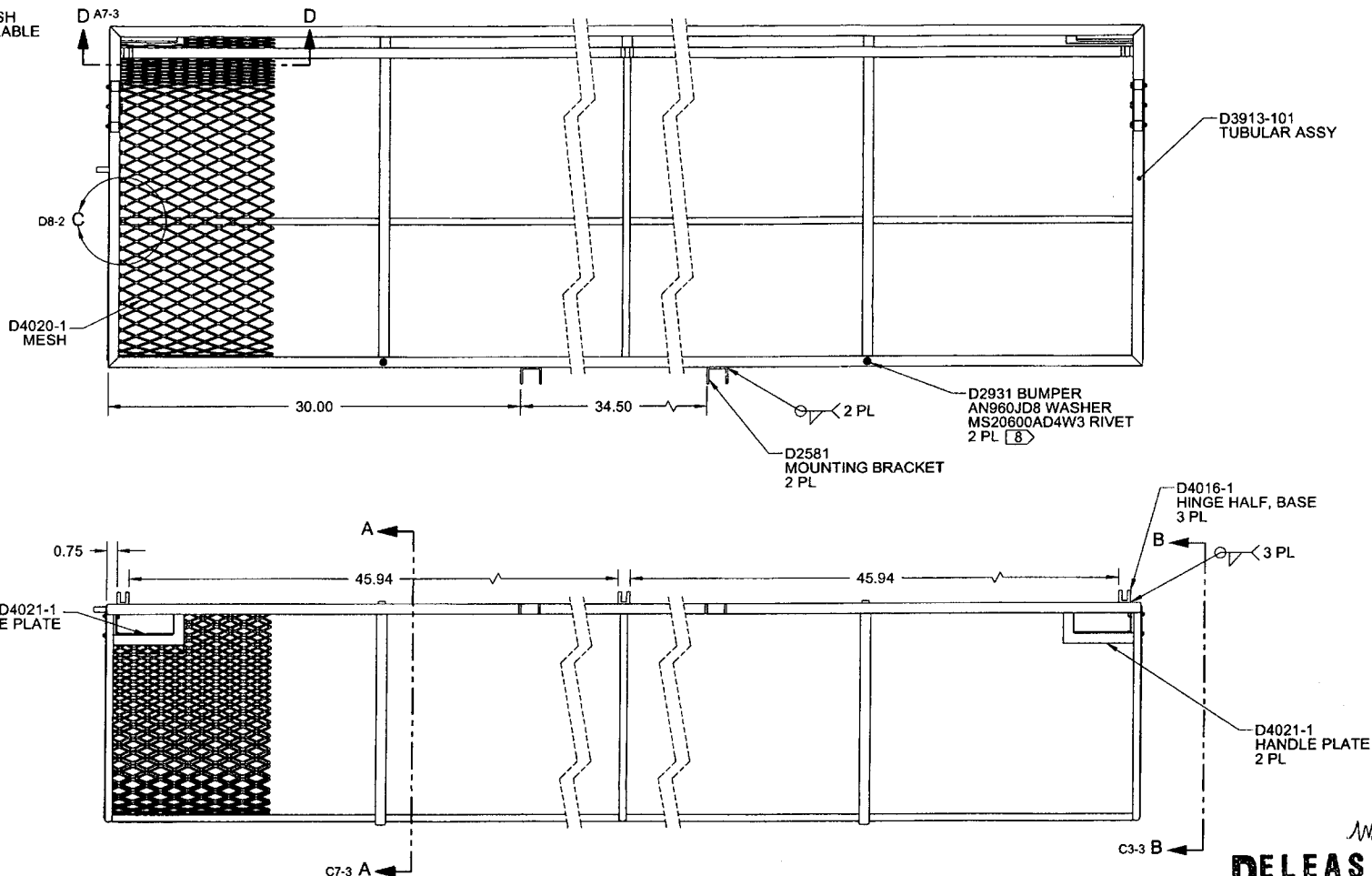
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL C D7-2

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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R 2010 -00- 77

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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52585

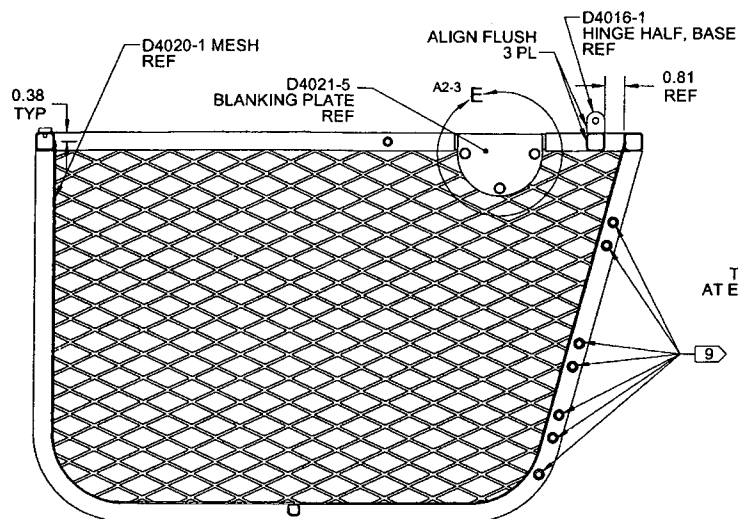
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

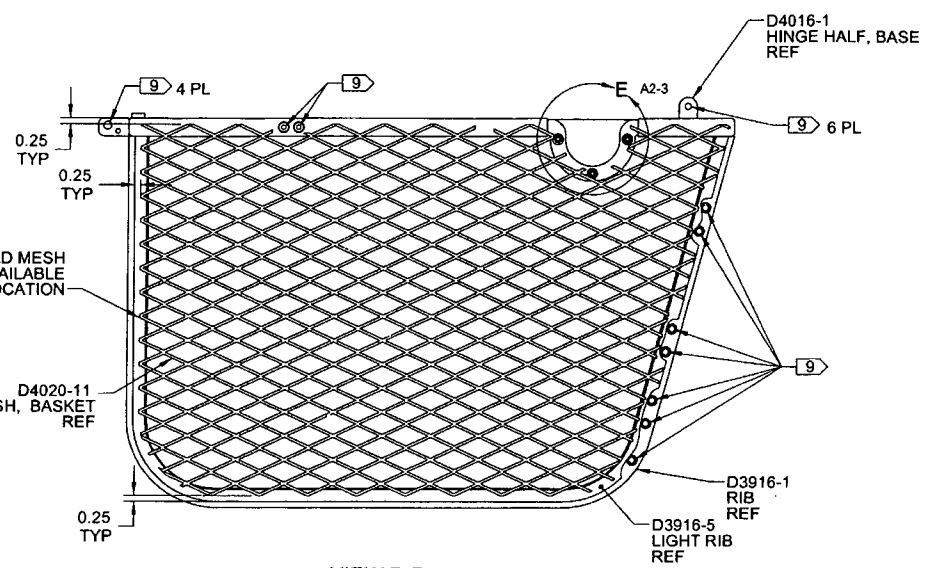
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

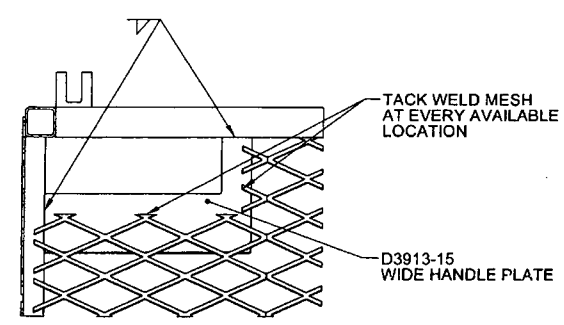
NOTE: Date & initial all entries



SECTION A-A A5-2

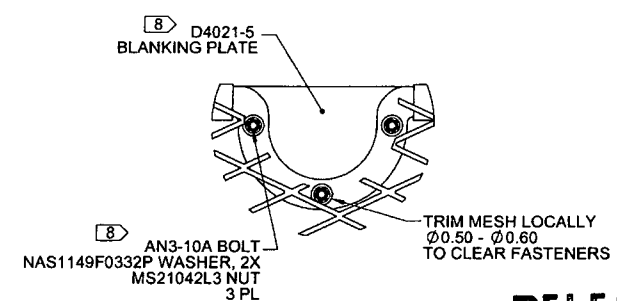


VIEW B-B A2-2







SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES

82885



DETAIL E D2-3
D6-3

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2010-03-22

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

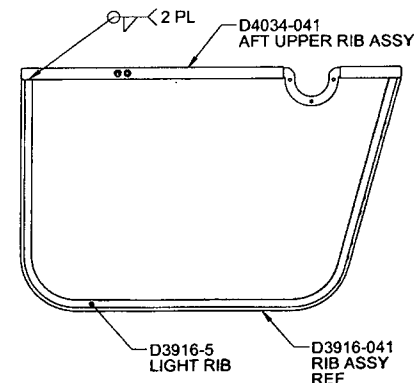
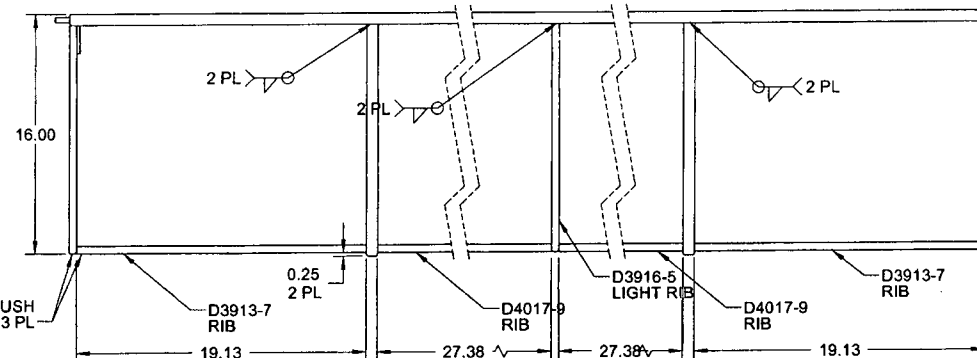
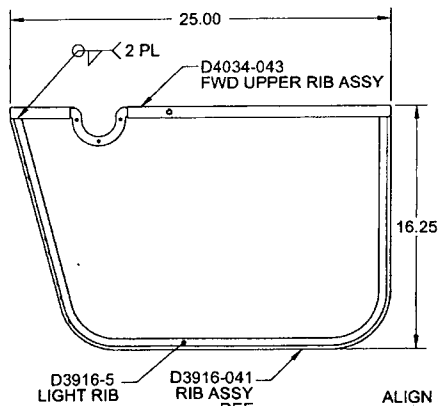
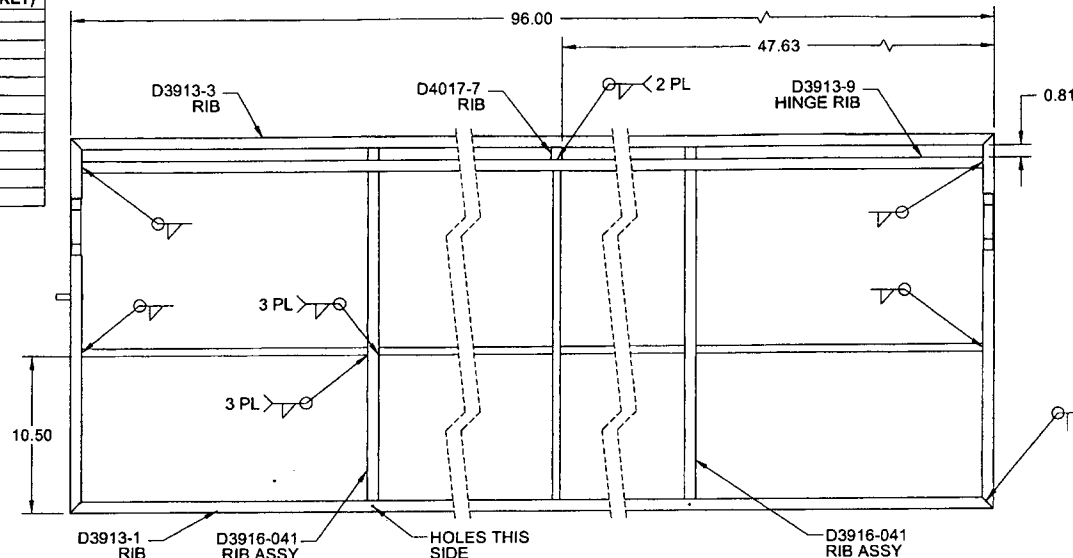
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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2010-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

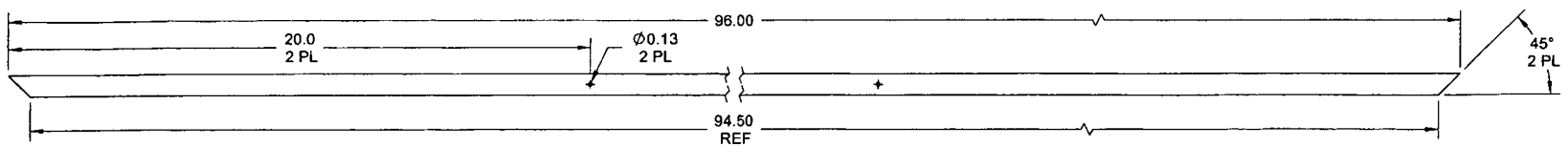
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

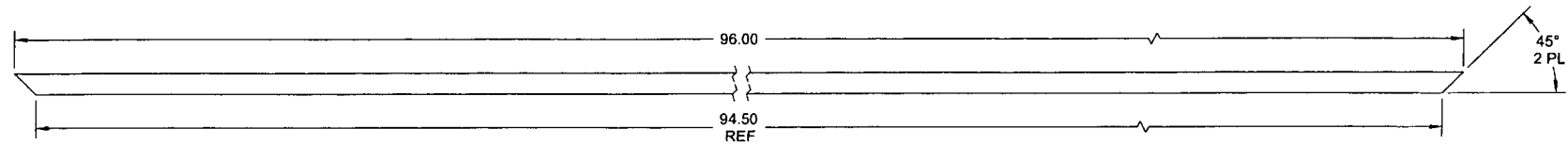
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

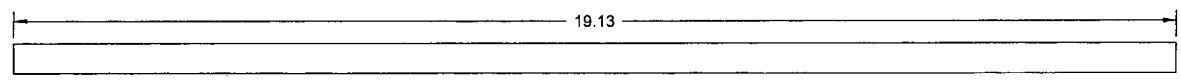
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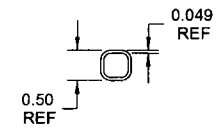
D3913-1 RIB



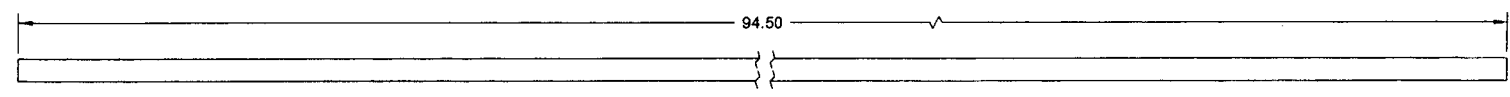
D3913-3 RIB



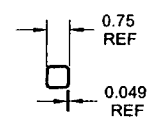
D3913-7 RIB



82885



D3913-9 HINGE RIB



NOTES:

- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750V.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500V.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

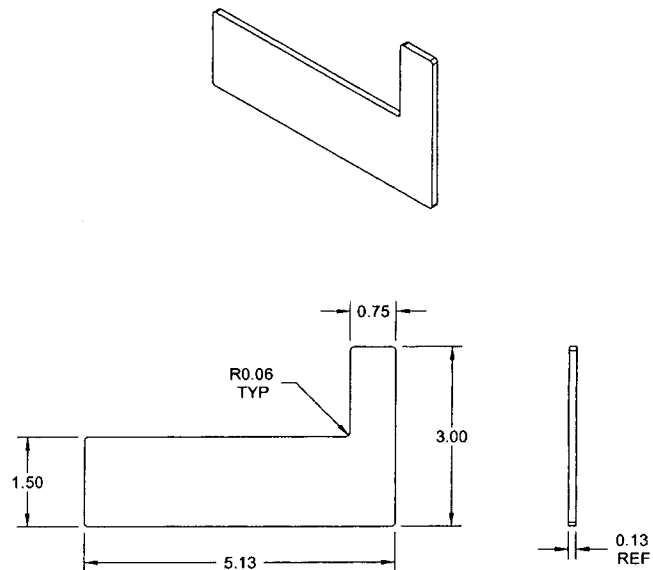
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

82585

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2010-03-22
JMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries